Qty:

60 Um:

Each

60

66

: BUSHING

: D26175

: N/A

: D2

: NIA

: 12/2/2005

D2617 REV D2

Tuesday, 11/22/2005 4:58:47 PM

User

Linda Lacelle

Process Sheet

Drawing Name

Part Number

Material **Due Date**

Drawing Number

Project Number

Drawing Revision

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 24942

Estimate Number

: 10310

P.O. Number

This Issue

Prsht Rev.

Written By

: NIA

: 11/22/2005

S.O. No. : WIA

: NC : 11/22/2005

First Issue Previous Run

: 24401

comment below

Checked & Approved By Comment

comment

: Est H 04.07.14 Reformat; added step 5 KJ/JLM

: MACHINED PARTS

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: 6061-T6 Tube .500 x.058W

1.0

M6061T6T0500W058



0.0205 f(s)/Unit Total:

1.2285 f(s)

6061-T6 Round Bar 1.5"

Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)

Ø0.500" tubing x 0.058" wall

M6061T6T0.500W.058)

Batch <u>M1726</u>7

Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA438 and Dwg D2617

Ø0.500" tubing x 0.058" wall

INSPECT PARTS AS THEY COME OFF MACHINE

3.0

5.0

2.0

QC2

HARDINGE

Comment: Qty.:

Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK TI

4.0 QC8



Comment: SECOND CHECK

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Deburr break all unmarked sharp edges 0.005 to 0.010

59

40

Dart Aerospace Ltd

W/O:	own same with a suppose.			* *** * ****** *	WORK OF	DER CHAN	GES	W 9-9-				
DATE	STEP			PROCEDU	JRE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:	PAR #:	Fault Category:		NCR: Yes (No) DQA:	Date: \S/a/02
		: 1	3	QA: N/C Closed:	Date:

NCR:	CR: WORK ORDER NON-CONFORMANCE (NCR)								
DATE	CTED	Description of NC	Initial	Corrective Action Section B	Verification	Approval	Approval		
DATE	SIEP	STEP Section A		Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
ij5~11·30	6,1	I port clibered to much on the side	dan	scrap destray	OSh 130	0511.30	Birds	ns 11 30	
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NOTE: Date & initial all entries

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Date: * Silver:	uesday 4.722/2005 4:58:47 PM inda	Process Sheet	
Custom	er_CU-DA ,001 Dart Helicopters Serv		BUSHING
0400011	Laure Mary	•	
Job Numb	er: 24942	Part Numbe	r: D26175
Job Number:	· 6		
Seq. #:	Machine Or Operation:		escription :
(A)	7 QC3	INSPECT POWDER COAT/C	HEMICAL CONVERSION
F			
Con	ment: INSPECT ALODINE	HAND FINIGUING DESCRIPT	M 05/1/ 101 57
MARE	HAND FINISHING1	HAND FINISHING RESOURC	
"\{\range{\range} Con	ment: HAND FINISHING RESOURCE		5 11 50
V 8.0	Acid etch and Alodine as per	QSI 005 4.1 INSPECT WORK TO CURRE	De 05/11/30 59
5.0		ING EST WORK TO SOURCE	Ja 12.01 55
Con	ment: INSPECT WORK TO CURRE	and the second s	
150	PACKAGING 1	PACKAGING RESOURCE #1	
Con	Iment: PACKAGING RESOURCE #1 Identify and Stock Location:		(0 5/12/0) 59
10.0	DC	DOCUMENT CONTROL	110000 1000 1000 1000
Con	ment: DOCUMENT CONTROL	545 0/ /	
	Inspection Level 21	5 45 05/12/05	59 105/12/02
Job Completion			

Dart Aerospace Ltd

W/O:	The matter day is a second of the second of	- the same same to the	WORK ORDER CHANGES							
DATE	STEP	PROCE	DURE CHANGE		confirmation and constant	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Category:	3	NC	R: Yes	s No DQ	A:	Date:	•
			1	And the second	1	QA:	N/C Close	ed:	_ Date: _	

	WORK ORDER NON-CONFORMANCE (NCR)									
	Description of NC		orrective Action Section B	Varification	A	Annessal				
SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto			
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	STEP	STEP Description of NC Section A	STEP Description of NC Section A Chief Eng	STEP Description of NC Section A Initial Chief Eng Corrective Action Section B Action Description Chief Eng Chief	STEP Description of NC Section A Initial Chief Eng Chi	STEP Description of NC Section A Initial Action Description Chief Eng Chief	STEP Description of NC Section A Description Section B Date			

NOTE: Date & initial all entries



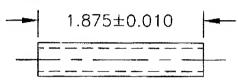


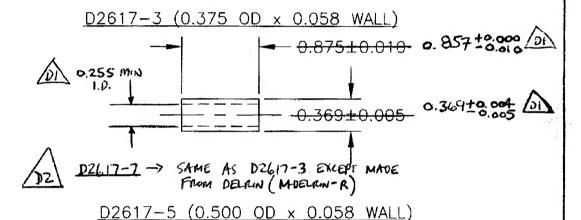
\	DESIG	BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
,	CHEC	KED #	APPROVED	DRAWING NO.	REV. D
		9	9	D2617 SHEET	1 OF 1
	DATE			TITLE	SCALE
	01.0	7.04	<u> </u>	BUSHING	1:1
	Α		96.10.08	NEW ISSUE	19
	В		97.05.08	.875 WAS 1.125	

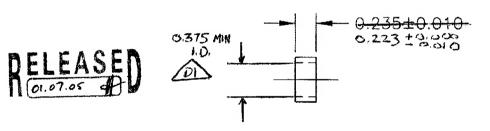
ADD 172617-7 04.09.10#12

97.06.04 0.369 DIA WAS 0.375 D 01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE CORRECT TELERANCE (NCR 779) 04,07.12

OD 0.058 WALL)







NOTES:

1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)

OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)

BREAK ALL SHARP EDGES 0.005 TO 0.010

3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD	Work Order: 2	4942
Description: Bushing	Part Number:	D2617-5
Inspection Dwg: D2617 Rev: D1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.223	+0.000/-0.010	0.219				
0.500	+0.005/-0.000	0.500				
		<u> </u>				
		<u> </u>				
,						

Measured by:	me	Audited by:	J.L	Prototype Approval:	N/A
Date:	05/1/27	Date:	05.11-27	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.08.09	New Issue	KJ/JLM	

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